



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3810

Job Sheet 168250



Part No: 646.3810

Job Qty: 5 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/28/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV N/C IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		11/27/17	0.00	0.00	Start Up Container		J.C.-L. 17-12-11
110	Mill Conv	5 pcs		11/28/17	0.00	1.64	Mill Conv 1		J.C.-L. 17-12-12
120	QC	5 pcs		11/28/17	0.00	0.00	QC2		J.C.-L. 17-12-12
130	QC	5 pcs		11/28/17	0.00	0.00	QC8		FK 17-12-12
140	Outsource	5 pcs		11/28/17	0.00	0.00	Outsource4		
150	Packaging	5 pcs		11/28/17	0.00	0.00	Packaging2		
155	QC	5 pcs		11/28/17	0.00	0.00	QC5		AK JAN 17 2018
180	Packaging	5 pcs		11/28/17	0.00	0.00	Packaging3	CC-K105	AT 18/01/18
190	QC21-SA	5 Ea		11/28/17	0.00	0.00	QC21		

Part Op 110 - 1-Machine per DWG

Descriptions: 140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 646.3800

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

DAS
21
5-03

JAN 19 2018

Job Allocations

M7075 T6 Al.000 x 0.75 x 0.125 x 0.060

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

Plex 11/14/17 7:15 AM dart.boucher.sylvie

DART AEROSPACE

S020538

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DE / UPDATE

Work Order update only ☐



Bracket

PART NO: 646.3810
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/12/17
Job No: 168250

AGAINST DEPARTMENT/PROCESS			
je ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
rg ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
rg ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
ab ☐	Composite ☐	Supplier ☐	
Active :			MRB (QSI042) Approval
Disposition			
			Completed By
			Lead hand / Supervisor Approval Verification

Root Cause		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐
Design ☐	Operator ☐	Bending ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/ Cuffs ☐
Material ☐	Use for Testing ☐	Crushing ☐
Internal Transport ☐	Poor Information ☐	Heat Treat ☐
Tribal Knowledge ☐	Rushing ☐	Wave/Twist in Tube ☐
LOA ☐	Product Improvement ☐	Marks/Chatter ☐
Substation ☐	Process Improvement ☐	
Past Expiry Date ☐	Manufacturing Process ☐	
Misidentified ☐	Past Due ☐	OTHER : ☐

DART AEROSPACE

S020538



Bracket

PART NO: 646.3810
Revision:
Operation: Outsource
Change No:

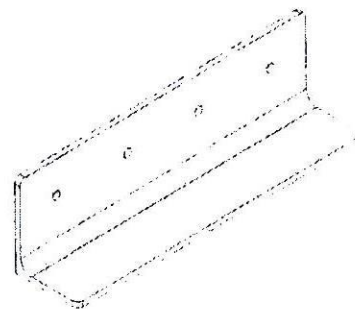
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 12/12/17
Job No: 168250

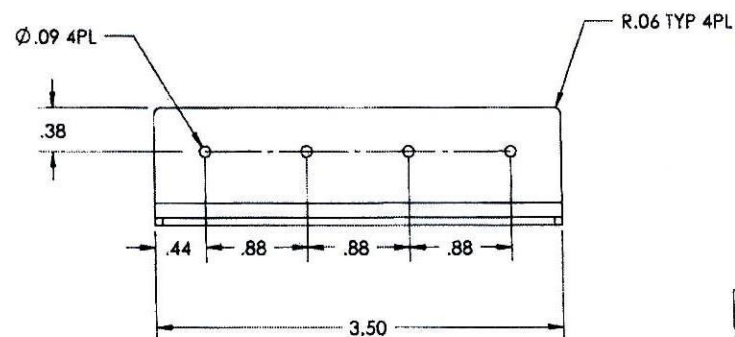
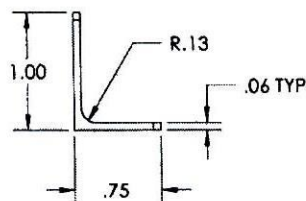
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

⚠ MATERIAL: ALUMINUM 7075-T651 AMS-QQ-A-250/12
 2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III.
 CLASS 2. COLOR BLACK;
 CARDINAL 4860-50 PRETREATMENT PRIMER
 PRIME IAW MIL-P-23377 J TYPE I CLASS N

3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



646.3810



UNINCORPORATED E.C. (S)

03697

[illegible]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
~~SUBJECT TO AMENDMENT~~
WITHOUT NOTICE
WORK ORDER
NO. 168 250

DAS
30
9-89

NOV 16 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038682

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038682
PO Date: 12/19/17
Due Date: 1/5/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
DEC 21 2017

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169179	649.4814	Doubler ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)	Firmed	1/17/18	10 pcs	0 pcs	10 pcs	\$7.25/pcs	\$72.50
2	168024	646.3812	Gusset Bracket Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.3800	Firmed	1/17/18	8 pcs	0 pcs	8 pcs	\$7.10/pcs	\$56.80
3	168250	646.3810	Bracket Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3800	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$7.55/pcs	\$37.75
4	168252	646.3812	Gusset Bracket Issue P/O to ATG : Hard Anodize Black and Prime as Per Dwg 646.3800	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$7.10/pcs	\$35.50
5	169178	649.4812	Shim ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2) PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)	Firmed	1/17/18	20 pcs	0 pcs	20 pcs	\$13.15/pcs	\$263.00
6	168253	646.3813	AS350 Strut Bracket Issue P/O to ATG :	Firmed	12/22/17	5 pcs	0 pcs	5 pcs	\$7.10/pcs	\$35.50



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914369

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 649.4814 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22189		Rev: D PO: PO038682 Line: 1
4 ea	Part: 646.3814 Wiper Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22202		Rev: N/C PO: PO038682 Line: 14
8 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22190		Rev: N/C PO: PO038682 Line: 2
5 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22191		Rev: N/C PO: PO038682 Line: 3
5 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing.		Rev: N/C

SP/8-01-11



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914369

Date: 05-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	- .9 mils) per drawing. Job: 22192 PO: PO038682 Line: 4		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>05/01/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>SP18-01-11</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel (613) 632-5200

Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: 646.3810 Revision: Bracket														
190	QC21-SA	S020538	168250	5 Ea	0	S020538	CCK105	Bin	Stock	12/12/2017	Issue Container			
Operation Totals:		1		5	0									
Part Totals:		1		5	0									
Part Number: M7075T6A1.00X0.75X0.125X0.060 Revision: 7075T6 Angle 1.0" X .75" X .125" X .060"W														
100	Receive Ft	S019698	168250	1 ft	0	m137084	Start Up Container		Stock	12/11/2017	Issue Container			
Operation Totals:		1		1	0									
Part Totals:		1		1	0									
Totals:		2		6	0									

Plex 1/19/2018 8:39 AM Dart.Lajeunesse.Marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			